

**Work Order ID 60238**

Page 1

Tuesday, June 29, 2010 11:49:19 AM

Item ID:	D4004-5	Accept		Setup	Start				
Revision ID:									
Item Name:	Bottom Strap Attach Bracket								
Start Date:	6/29/2010	Start Qty:	2.00		Cust Item ID:				
Required Date:	7/6/2010	Req'd Qty:	2.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:		Date: 10/6/29	Tooling:	Date:		Stop		
	QC:		Date: _____	SPC (Y/N):	Date: _____				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4004	A	

100		0.00	
-----	--	------	--

	BAND SAW	0.00	
Bandsaw	Memo	0.00	

Jeaspa Bandsaw

1-Cut D3033-144 extrusion to length per D4004-5 detail of dwg D3033

Ensure cut is started at correct place per dwg

Batch: 30209

2-Deburr

105		0.00	
-----	--	------	--

	Small Fab	0.00	
Small Fab	Memo	0.00	

Drill and c'sink holes as per dwg and trim part to lenght as required.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60238**

Tuesday, June 29, 2010 11:49:19 AM



Page 2

Item ID: D4004-5

Accept



Setup

Start



Revision ID:

Item Name: Bottom Strap Attach Bracket

Stop



Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

510108125

72

120



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

M 10/08/25

X2 0

Hand Finishing

130



QC

QC3- Inspect Part Finish

0.00

Quality Control



Memo

0.00

M 10 08 25 (2)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4004-5

Accept



Setup Start



Revision ID:

Item Name: Bottom Strap Attach Bracket

Stop



Start Date: 6/29/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/6/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

Identify as per dwg & Stock Location: 110

0.00

10/8/25 208

Packaging

Packaging

Memo

0.00

150



QC21- Final Inspection - Work Order Release

0.00

10/08/26 10

QC

Quality Control

Memo

0.00

MT  
10-8-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

# Picklist Print

Tuesday, June 29, 2010 11:49:23 AM

Page 1

Work Order ID: 60238



Parent Item: D4004-5



Parent Item Name: Bottom Strap Attach Bracket

Start Date: 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.15 new issue EC verified by:DD  
10.05.17 as per ECN10-562 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3033-144		Manufactured	No		100	f	33.7633	0.41	0.863158				
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Location	Loc Qty	Loc Code
ST492	33.7633	
30209	3.7633	
58045	30	

Location

Loc Qty

Loc Code

Seat Track

0.863158

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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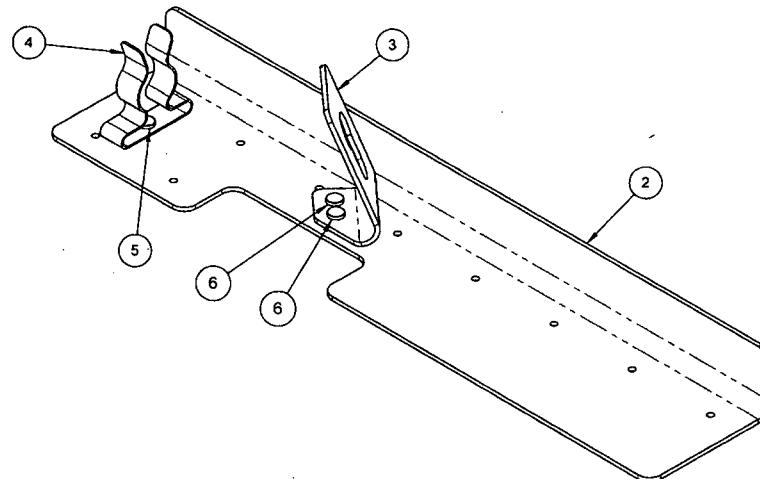
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-041	SIDE RESTRAINT ANGLE	JCA-M47-2-19
2	1	D4004-1	SIDE RESTRAINT	
3	1	D4004-3	STRUT LOCK BRACKET	
4	1	D4004-7	HOSE CLIP	
5	1	MS20426AD4-4	RIVET	
6	2	MS20426AD4-5	RIVET	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *66235*

*2810-6-29*



D4004-041 SIDE RESTRAINT ANGLE

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-041" AND B/N USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.21 lbs

A	NEW ISSUE	REV.	BY	DATE
DESIGN	<i>BS</i>			10.02.10
DRAWN	<i>BS</i>			
CHECKED	<i>BS</i>			
MFG. APPR.	<i>BS</i>			
APPROVED	<i>BS</i>			
DE APPR.	<i>BS</i>			
DATE	10.02.10			

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4004** REV. A  
SHEET 1 OF 11

TITLE **SIDE RESTRAINT** NTS

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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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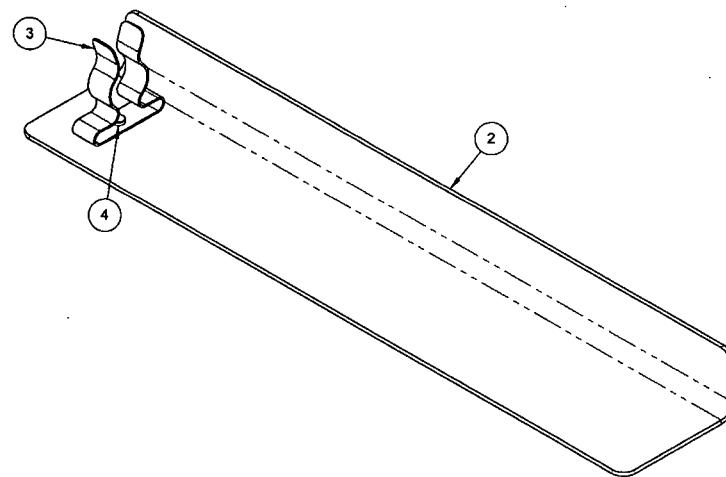
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4004-043	SIDE RESTRAINT ANGLE AND TIE DOWN POINT	JCA-M47-2-04
2	1	D4004-9	ANGLE	
3	1	D4004-7	HOSE CLIP	
4	1	MS20426AD4	RIVET	



Wb 66288

D4004-043 SIDE RESTRAINT ANGLE AND TIE DOWN POINT

RELEASED  
2010-05-05  
M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-043" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.20 lbs

DESIGN	<i>5</i>	DART AEROSPACE LTD
DRAWN	<i>5</i>	HAWKSBUARY, ONTARIO, CANADA
CHECKED	<i>5</i>	DRAWING NO. <b>D4004</b> REV. A
MFG. APPR.	<i>5</i>	SHEET 2 OF 11
APPROVED	<i>5</i>	TITLE <b>SIDE RESTRAINT</b> NTS
DE APPR.	<i>5</i>	DATE <b>10.02.10</b>

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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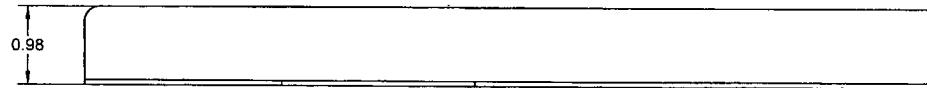
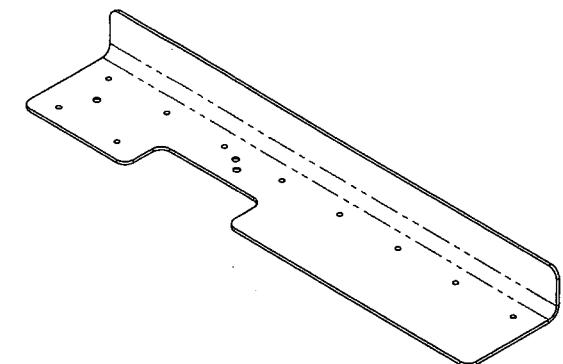
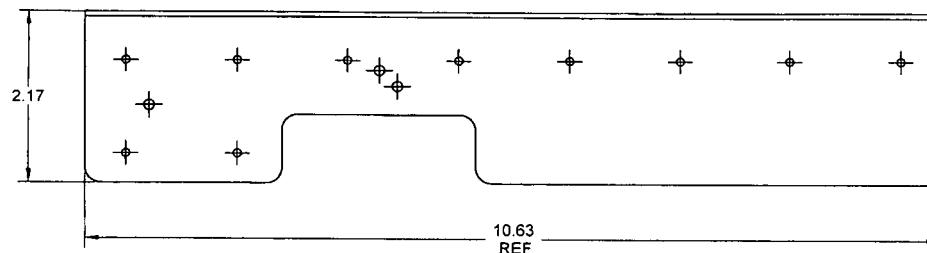
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-1	REF JCA-M47-2-19



D4004-1 SIDE RESTRAINT

RELEASED  
2010-05-05  
M

NOTES:  
 1) MATERIAL: MADE FROM D4004-1F  
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.18 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.		SHEET 3 OF 11
APPROVED		D4004
DE APPR.		TITLE
DATE	10.02.10	SCALE
		NTS
		SIDE RESTRAINT
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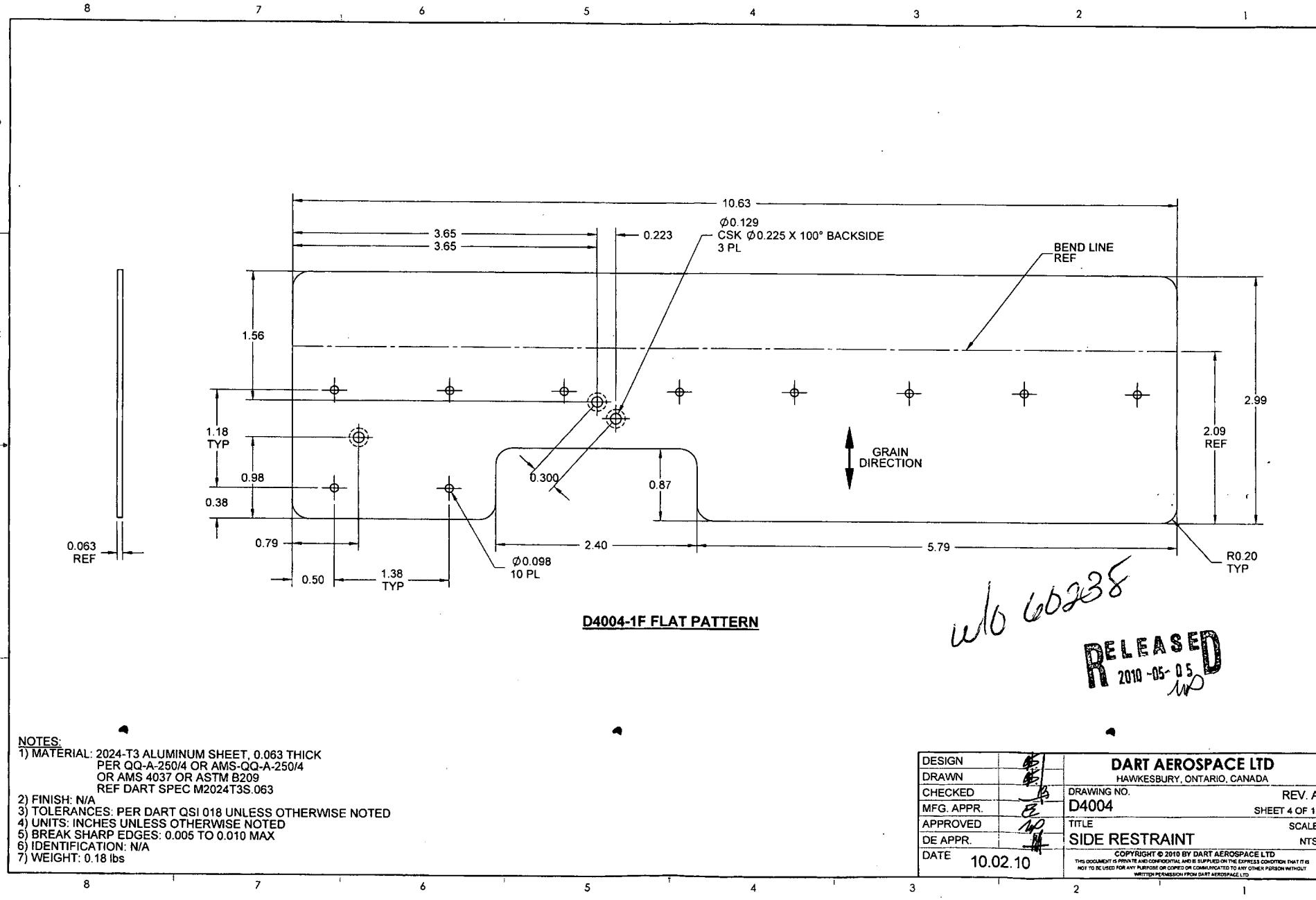
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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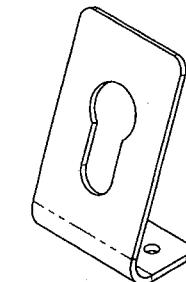
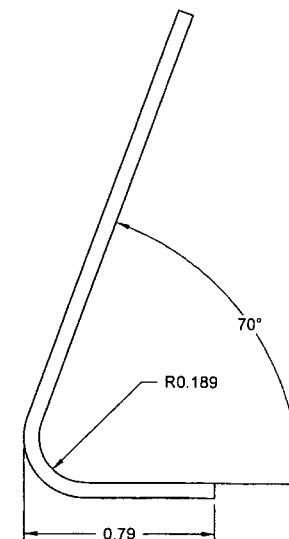
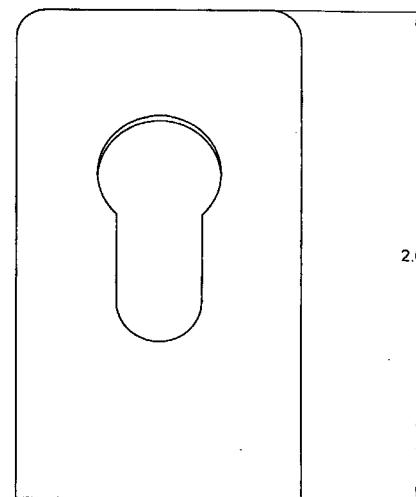
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-3	REF JCA-M47-2-19

D

C

B

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wb 66238

D4004-3 STRUT LOCK BRACKET

NOTES:

- 1) MATERIAL: MADE FROM D4004-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN	<i>E</i>	DART AEROSPACE LTD
DRAWN	<i>E</i>	HAWKSLEY, ONTARIO, CANADA
CHECKED	<i>B</i>	
MFG. APPR.	<i>E</i>	REV. A
APPROVED	<i>E</i>	SHEET 5 OF 11
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DATE	10.02.10	SCALE
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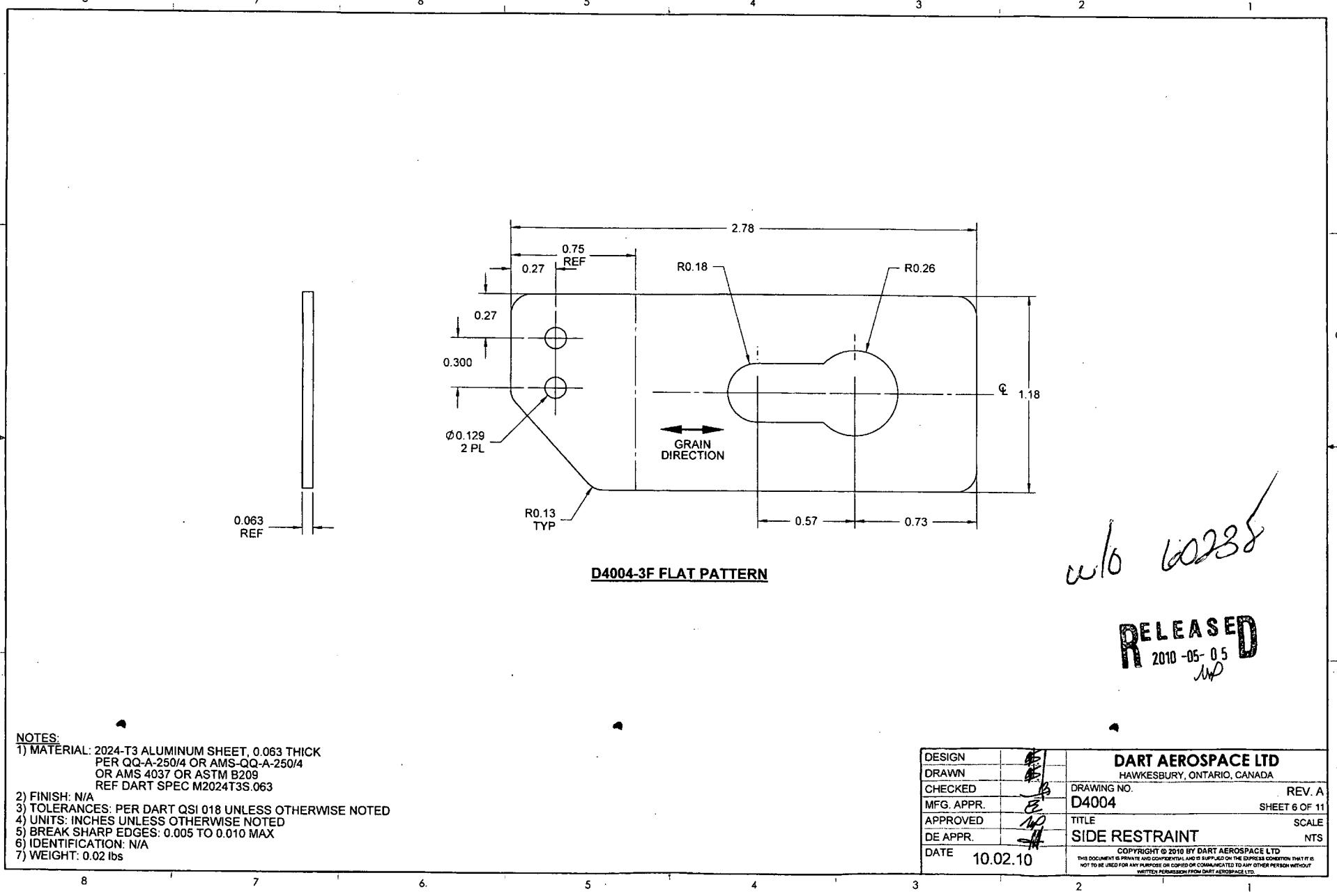
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-5	JCA-M47-2-23

D

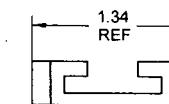
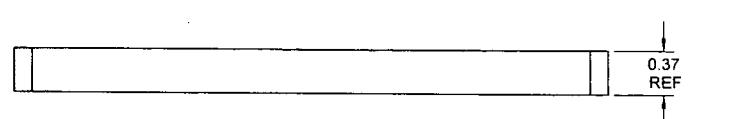
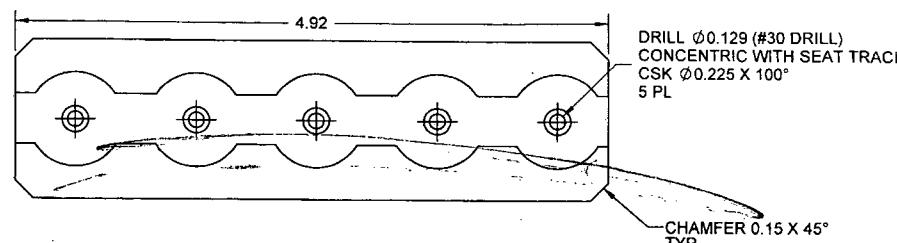
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ar 10 2028

D4004-5 BOTTOM STRAP ATTACH BRACKET?

RELEASED  
2010-05-05  
NP

NOTES:

- 1) MATERIAL: MADE FROM ANCRA P/N 40456-11-144  
OR BROWNLINE P/N 20276-144-0-0  
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-5" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		
MFG. APPR.		REV. A
APPROVED		SHEET 7 OF 11
DE APPR.		SCALE
DATE	10.02.10	NTS

DRAWING NO. D4004  
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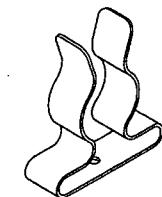
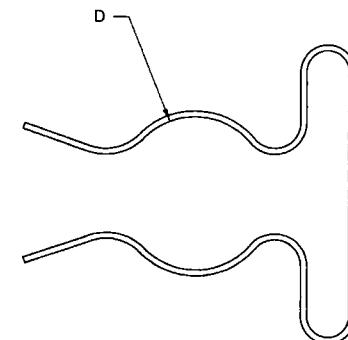
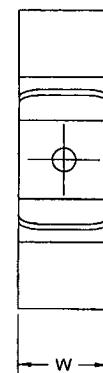
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-7	N3 REF JCA-M47-2-19

## SPECIFICATION CONTROL DRAWING



DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	FITS TUBE $\phi$ "D"	WIDTH "W"
D4004-7	MCMASTER-CARR	1722A42	NICKEL PLATED STEEL	0.31 - 0.75	0.38

WB 60235

### D4004-X HOSE CLIP

NOTES:  
 1) MATERIAL: SEE TABLE  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-X" USING FINE POINT PERMANENT INK MARKER  
 7) WEIGHT: 0.01 lbs

DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO.	
MFG. APPR.	<i>BB</i>	REV. A	
APPROVED	<i>BB</i>	D4004	
DE APPR.	<i>BB</i>	SHEET 8 OF 11	
DATE	10.02.10	TITLE	
		SIDE RESTRAINT	
		NTS	
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8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

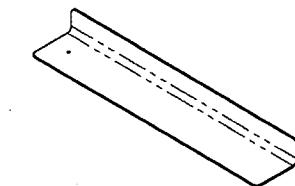
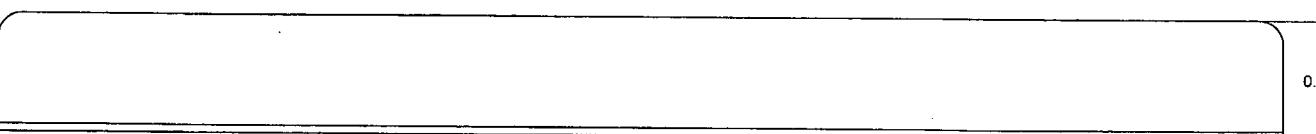
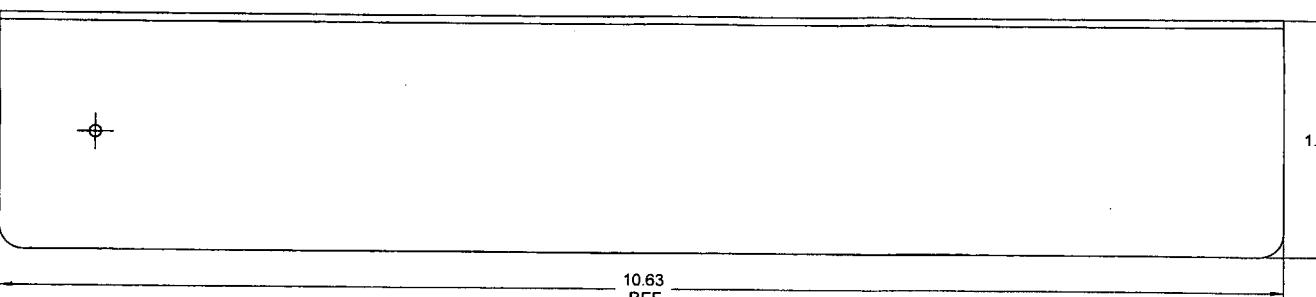
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-9	REF JCA-M47-2-04

D



D4004-9 ANGLE

w/0 66238  
RELEASED  
2010-05-05  
MD

A

NOTES:

- 1) MATERIAL: MADE FROM D4004-9F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART OSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.		D4004
APPROVED		SHEET 9 OF 11
DE APPR.		TITLE
DATE	10.02.10	SCALE
		SIDE RESTRAINT
		NTS
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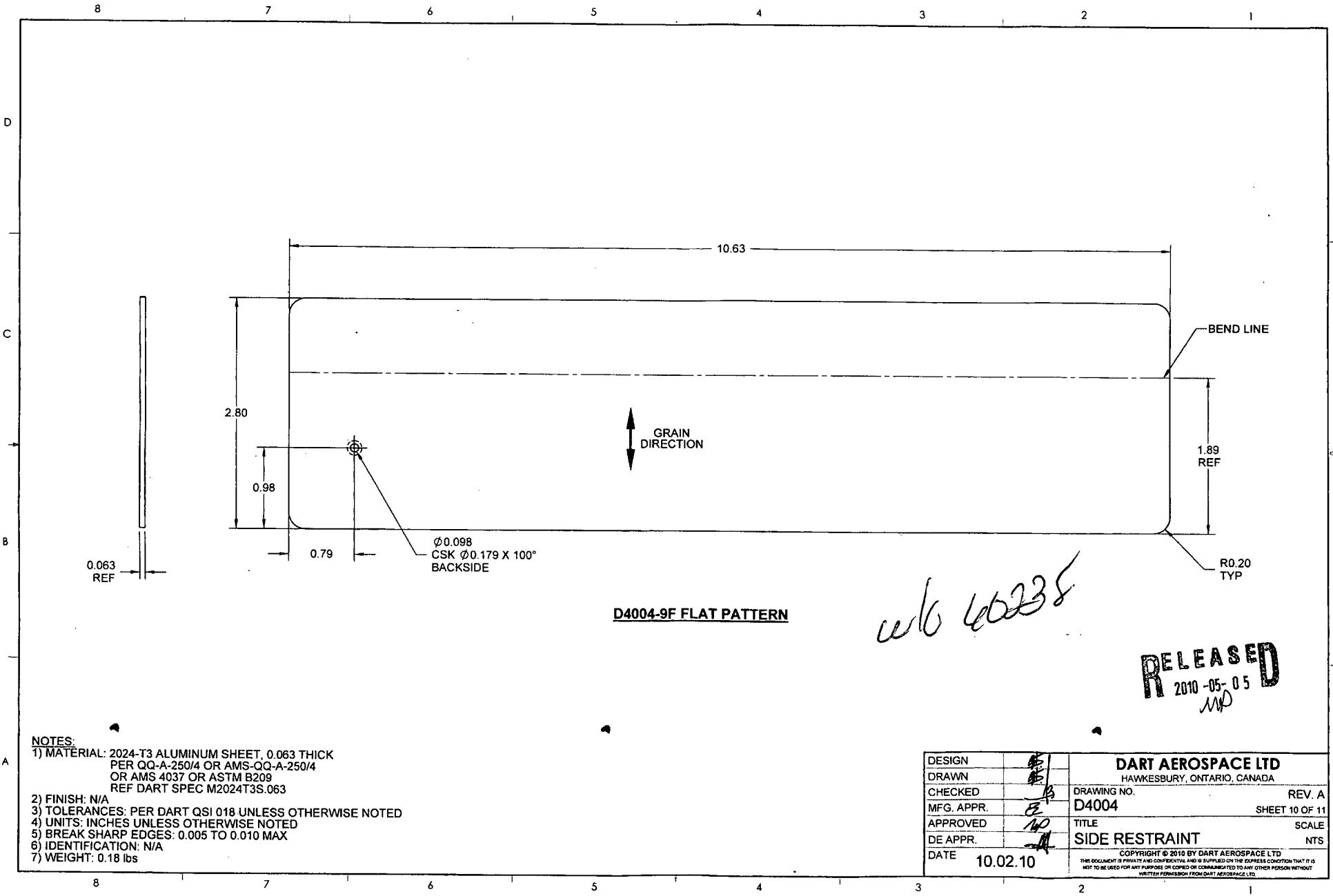
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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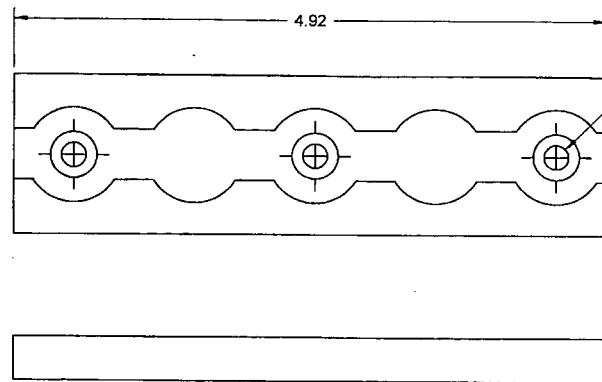
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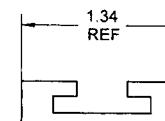
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4004-11	JCA-M47-2-11

D

D



DRILL Ø0.204 (#6 DRILL)  
CONCENTRIC WITH SEAT TRACK  
CSK Ø0.385 X 100°  
3 PL



W66238

D4004-11 TOP STRAP ATTACH BRACKET

RELEASED  
2010-05-05  
M

A NOTES:

- 1) MATERIAL: MADE FROM ANGRA P/N 40456-11-144  
OR BROWNLIN P/N 20276-144-0-0  
OR D3033-144
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4004-11" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

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DESIGN	<i>BB</i>	DART AEROSPACE LTD	
DRAWN	<i>BB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BB</i>	DRAWING NO.	
MFG. APPR.	<i>BB</i>	D4004	REV. A
APPROVED	<i>BB</i>	TITLE	SHEET 11 OF 11
DE APPR.	<i>BB</i>	SIDE RESTRAINT	NTS
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